

Date: Friday, 10/12/2007 1:11:54 PM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 35156		
Estimate Number	: 11470		
P.O. Number	: N/A	Part Number	: D314099
This Issue	: 10/12/2007	Drawing Number	: D3140 REV F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: F
Previous Run	: 31465	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 10/19/2007
Checked & Approved By	: <u>[Signature]</u>	Qty:	2
Comment	Est. A02.04.30 New Issue NG Est. Rev B New dwg rev. ecn781 06.04.18 EC Est. rev.C added scuffing NCR 061 EC Est Rev:D As per ECN #829 06-11-20 JLM Est Rev:E Now On Waterjet 07-03-28 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S032	2024-T3 .032 sheet
Comment: Qty.: 0.1422 sf(s)/Unit Total : 0.2843 sf(s) 2024-T3 .032 sheet Matl: 2024-T3 (QQ-A-250/4) .032" thick (M2024T3S.032) Batch <u>M105555</u> <u>B07-10-15</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3140 Dwg Rev: <u>F</u> <u>B07-10-15</u> Prog Rev: <u>F</u> 2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>CF</u> <u>07/10/15</u> <u>(47)</u>		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 01/11/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Scuff surfaces with 80grit sandpaper per QSI 006

2-Deburr.

No sharp edges

Handwritten: [Signature] 07/10/15 (2)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: FL 07/10/16 (2)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: [Signature] 07/10/16 (2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Handwritten: [Signature] 07/10/16 (2)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: [Signature] 07/10/17 (2)

Job Completion



Handwritten: U 07.10.17

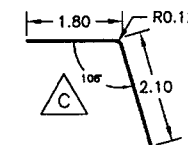
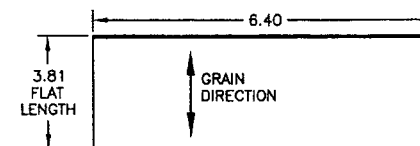
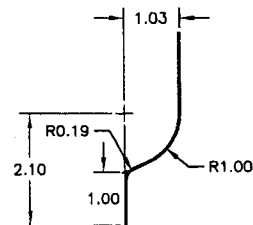
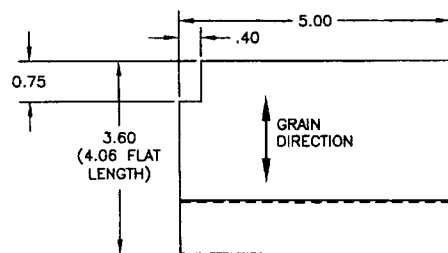
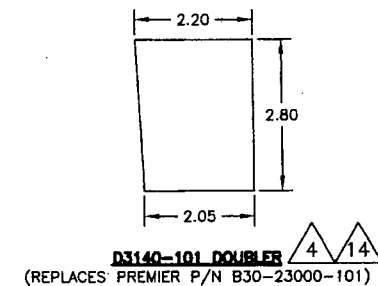
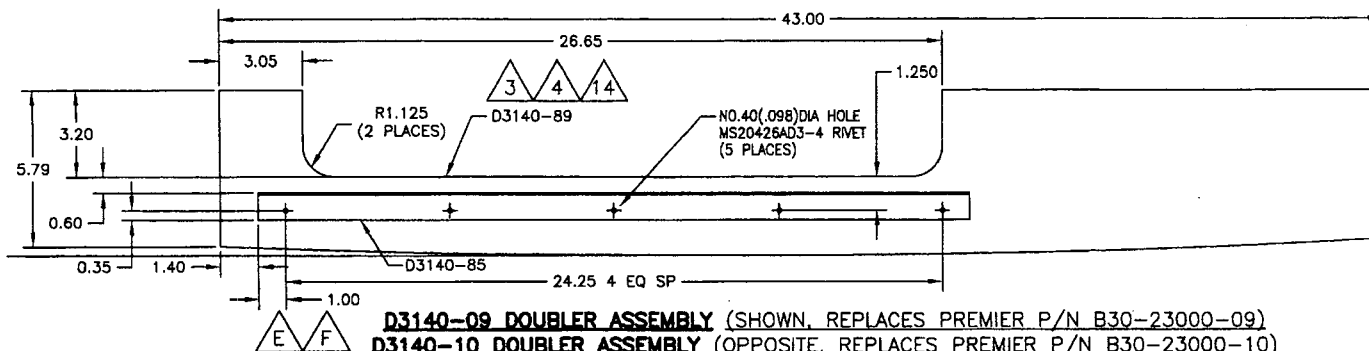
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



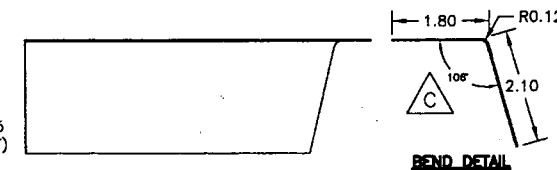
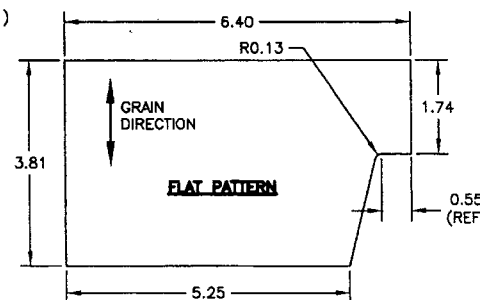
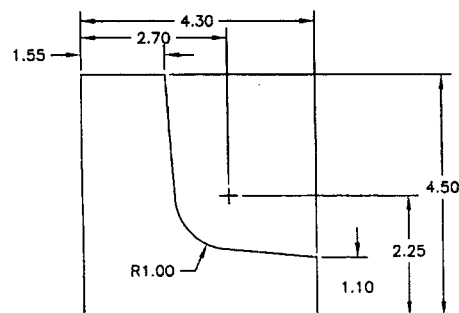
D3140-91F FLAT PATTERN
(USE TO MAKE D3140-91/-92 DOUBLERS)

D3140-92 DOUBLER (4, 14, F)
(SHOWN, REPLACES PREMIER P/N B30-23000-92)
D3140-91 DOUBLER
(OPPOSITE, REPLACES PREMIER P/N B30-23000-91)

D3140-95 DOUBLER (4, 14)
(REPLACES PREMIER P/N B30-23000-95)

RELEASED

06.11.13



D3140-97 DOUBLER (4, 14)
(SHOWN, REPLACES PREMIER P/N B30-23000-97)
D3140-98 DOUBLER
(OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

BEND DETAIL

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DESIGN 4	DRAWN BY CB	DART AEROSPACE LTD. HAINESBURY, ONTARIO, CANADA
CHECKED JH	APPROVED H	DRAWING NO. D3140
DATE 06.10.06	TITLE DOOR	REV. F SHEET 5 OF 7 SCALE NTS

